

Work Order ID 83540

83540

Page 1

April-19-12 11:24:22 AM

Item ID: D2137

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Decal - No Step

Start Date: 19/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLO

Date: 12/04/19 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2137

120418
Jan 29 1992

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O 16772
Make per Dwg 2137

12-04-19

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

12/4/19 (12)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Sc7/4/19

(42)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 83540

83540

Page 2

April-19-12 11:24:22 AM

Item ID: D2137

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Decal - No Step

Start Date: 19/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: **STGA** 0.00

130

Packaging

Memo

0.00

Packaging

12x **SP**
12-04-24.

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/4/25
12-04-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

April-19-12 11:24:28 AM

Page 1

Work Order ID: 83540

83540

Parent Item: D2137

D2137

Parent Item Name: Decal - No Step

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B02.02.01 Added step 3 and Inspection level 21 SM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2137P | | Purchased | No | | | 100 | Each | 0.0000 | 1 | 12 | | | |

D2137P

Decal - No Step

**

12/24
(12)

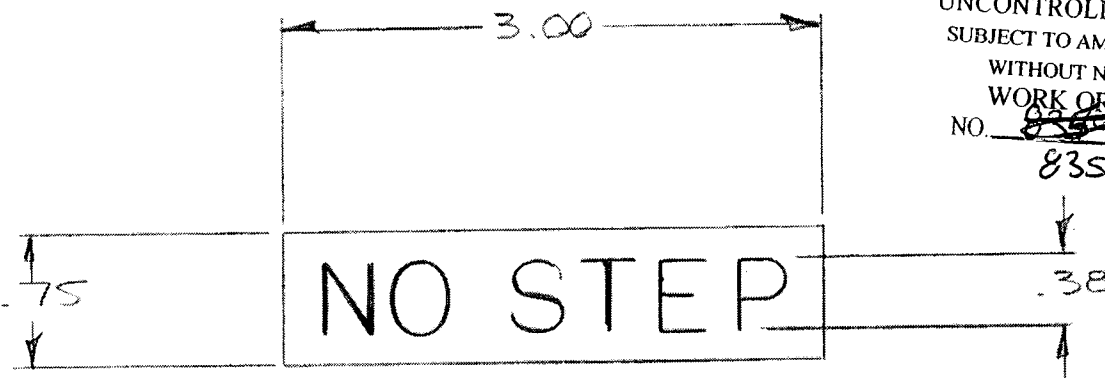
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. ~~83540~~ MLJ
83540 12/04/19

ALTERNATE MATERIAL:

3M 7 MIL MASKING FILM #8522CP

SILVER OR WHITE ON BLACK

off 00 09.05
CP 00 09.05

MATERIAL: 3M POLYESTER

NATURAL (SILVER OR
WHITE) ON BLACK.
.003 THICK



| | | | | | | | | | | | | | | | |
|---|--|--|--|---|--|---|--|-------------------------------|--|-------------|--|----------|--|-----------------------------------|--|
| REVISION | | THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO. | | RIVET CODE SHALL BE PER NAS 523 | | PART NO. | | ITEM | | DESCRIPTION | | MATERIAL | | SPEC. VENDOR | |
| DRAWN | | | | BASIC CODE | | CONTRACT NO. | | DRAWN | | DATE | | DART | | DART AERO ACCESSORIES INC. CANADA | |
| APPROVED | | | | D=HOLE DPT=NO OF SHEETS C=COUNTERSINK | | DIA. DASH NO. R=HEAD RADIUS F=HEAD FAR SIDE | | DESIGN | | 92 | | | | | |
| DESCRIPTION | | REQUIREMENTS — UNLESS OTHERWISE SPECIFIED | | LIMITS | | BASIC CODES | | STRESS | | | | TITLE | | DECAL - NO STEP | |
| OF | | GENERAL | | 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 8 - 3242 5. HOLES PER AND 10387 | | 1. TOLERANCES — .001 2. ANGLES — .010 3. PARALLELISM — .0025 4. ECCENTRICITY — .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005 | | LENGTH DASH NO. W=SPOTWELD | | | | CODE | | D2137 | |
| CHANGE | | | | | | 8A=MS20470AD 8B=MS20428AD | | CHECKED | | | | DWG NO. | | REV | |
| | | | | | | | | CLIENT | | | | SCALE | | SHT 1 OF 1 | |
| REPORT ALL DISCREPANCIES — DO NOT SCALE | | | | | | | | | | | | | | | |

D2137

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 17779
Date: 04/23/2012
Ship Date: 04/23/2012
Page: 1
Re: Order No. WO7146

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

| Item No. | Unit | Quantity | Description | Tax | Unit Price | Amount |
|--|------|----------|----------------------------------|-----|--------------|--------|
| | | 12 | Autocollant D2137R PO # 16772 | H | 6.25 | 75.00 |
| | | | H - HST 13% HST | | | 9.75 |
| | | | PST Exempt: #6122-5207 | | | |
| Studio de Lettrage HST: #825007651RT0001 | | | | | | |
| Shipped By: Tracking Number: | | | | | Total Amount | 84.75 |
| Comment: | | | | | | |
| Sold By: | | | | | | |

Product & Instruction Bulletin 8522

Release 1, Effective September 2008

See Bulletin Change Summary and end of Bulletin

This Bulletin now includes Instruction Bulletin 4.23

Scotchcal™ Changeable Opaque Imaging Media 8522

For Thermal Inkjet Printing

Product Description

This durable, 7 mil, opaque, changeable film is optimized for use with selected thermal inkjet printers and inks. Ink dries quickly on the film. When overlaminated, it is warranted for medium term, outdoor weatherable graphics, and long term indoor graphics.

Recommended Types of Graphics and End Uses

When constructed and used as described in this Bulletin, these types of graphics and end uses may be warranted by the 3M™ MCS™ Warranty. Please read the entire Bulletin for details.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics
 - Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

3M specifically does not recommend or warrant the following uses, but please contact us to discuss your needs or recommend other products.

Unsuitable End Uses for This Product

- Not for electronically cut individual letters and numbers
- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wallboard
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.
- Graphics made for automotive Original Equipment Manufacturers (OEM); contact 3M Automotive Division at 1-800-328-1684 for alternatives.

About Water-Based Inkjet Technology

Standard inkjet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this Bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products

3M Graphic Materials

For complete details about graphic construction options, recommended uses and durability, refer to the Product Bulletin for the base film or substrate (media) you are using. See **3M Related Literature** at the end of this Bulletin.

This Bulletin provides details about the base film and construction options and warranty. Additional specific information about compatible products can be found in the Product and Instruction Bulletins listed in **3M Related Literature** at the end of this bulletin.

3M Graphic Materials

For complete details about graphic construction options, recommended uses and durability, refer to the Product Bulletin for the base film or substrate (media) you are using. See **3M Related Literature** at the end of this Bulletin.

Film

- 3M™ Scotchcal™ Opaque Imaging Media 8522

Overlamine

- 3M™ Scotchcal™ Luster Overlamine 8519
- 3M™ Scotchcal™ Matte Overlamine 8520

Printers and Inks

| HP Designjet Printers | HP Inks |
|---|--|
| <ul style="list-style-type: none"> • 2500CP and 2000CP • 2800CP and 3800CP • 3500CP and 3000CP • HP Designjet 5000 and 5500 | <ul style="list-style-type: none"> • Designjet CP Ink System UV (pigment-based) • Designjet CP Inkjet System (imaging ink) |
| <ul style="list-style-type: none"> • Z6100 | <ul style="list-style-type: none"> • HP 91 Vivera Ink System |
| Epson Printers | Epson Inks |
| <ul style="list-style-type: none"> • Stylus Pro 9500 • Stylus Pro 10000 printer • Stylus Pro 10600 printer | <ul style="list-style-type: none"> • Archival Inks |

Characteristics

These are typical values for unprocessed product; processing may change the values. Contact your 3M representative for a custom specification.

| Characteristic | Description |
|----------------------------------|--|
| Media | 7 mil, white, opaque graphic film |
| Liner | Low-slippage, lay flat paper |
| Adhesive | Changeable, pressure sensitive |
| Thickness | Media with adhesive: 7.5 to 8 mil (nominal) |
| Warranted application substrates | See next page. |
| Application surfaces | Flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications (no corrugations) |
| Application temperature range | 28° to 110°F (-2° to 43°C) (air and surface) |
| Removable | For up to one year; see Warranty Information |

| Characteristic | Description |
|----------------------------------|--|
| Warranted application substrates | <p>Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.</p> <ul style="list-style-type: none"> • Alodine (anodized aluminum) • Automotive panels (automotive painted steel) • Fruehauf (painted aluminum) • FRP (fiberglass reinforced plywood) • Glass • Imron® (polyurethane-painted metal panel) • Acrylic • Sintra™ board <p>Note: Use on any other substrate is strictly on a graphics manufacturer and customer test and approve basis. Test for both adhesion and removal characteristics. The plasticizer in some banner materials may migrate. This may cause the edge of the graphic to peel or lift off of the banner. For optimum performance, follow the guidelines in the section, Creating A Laminated Overlap, on page 4.</p> |

Warranty Information

The warranty given in the Product Bulletin that is current at the time you purchased the film is the one that 3M will honor. **The warranties in the following table(s), given in years, are for finished graphics exposed in a vertical exposure in the United States except the Desert Southwest.** See the warranty sections following this table for additional information.

3M™ MCST™ Warranty Durability for Finished Graphics

| Construction (film and overlamine on warranted substrate) | HP Printers & Inks | | Epson Printers & Inks | | Removal |
|---|--------------------|---------|-----------------------|---------|--|
| | Outdoor | Indoor | Outdoor | Indoor | |
| 8522/8519 | 3 years | 5 years | 2 years | 5 years | 1 year without chemical strippers or tools |
| 8522/8520 | | | | | |

Warranty and Limited Remedy

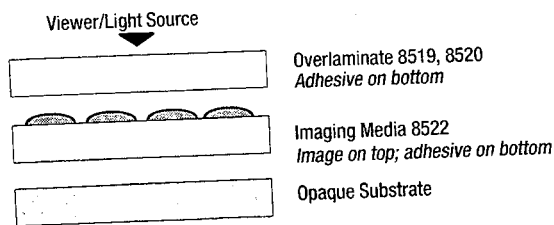
The following is made in lieu of all other express or implied warranties, including any implied warranty of **merchantability** or fitness for a particular purpose or implied warranty arising out of a course of dealing, custom or usage of trade: all 3M products are warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in this Product Bulletin. 3M will replace or refund the price of any 3M materials that do not meet this warranty within the specified time periods. These remedies are exclusive. **In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor or non-3M materials charges.**

See the Graphics Market Center Warranty Brochure, which gives the terms, additional limitations of the warranty, if any, and limitations of liability.

Graphic Construction Options

Opaque Graphics

Opaque graphics made with imaging media 8522 require an overlamine and an opaque substrate.



Fabrication

Shop Temperature

Acceptable: 60° to 95°F (15° to 35°C)
Optimum: 65° to 73°F (18° to 23°C)

Shop Humidity

Acceptable: 20% to 80%
Optimum: 45% to 60%

Condition the Media Before Use

These steps are especially important if you are operating outside the conditions recommended under Fabrication, above.

- Leave the media in its original packaging until you are ready to condition and use it.
- The day before you need it, remove the media from the box and remove the plastic.
- Condition the media for 24 hours in the same environment as the printer.

Refer to your Hewlett Packard printer manual for detailed operating instructions.

The quality of a printed image depends on a combination of factors: correct media selection, printing software and raster imaging processor (RIP), shop conditions, etc.

The printers qualified to use this media have print mode options that are programmed specifically for these media. Current charts that show the various modes and printing dpi, and the quality results you can expect are available at www.hp.com under the website's support section. We recommend that you print the same image at all of these settings to determine acceptable print and productivity results.

The highest quality settings are usually desirable for backlit applications.

The correct media selection makes most other necessary adjustments to the printer.

- For the HP DesignJet CP 2000 or 3000 series printers, select the **Opaque Vinyl UV** setting.
- For the HP Designjet 5000 series printers, select the **3M Changeable UV** setting or the **HP Durable Gloss UV** or **HP Colorfast Vinyl** setting.
- For the Z series printers, refer to HP's website or printer manuals.

Note: The HP printer settings lay down less ink per pass, which results in better ink absorption and quicker drying times.

- For the HP DesignJet CP 2000 or 3000 series printers, select the **Opaque Vinyl UV** setting.
- For the HP Designjet 5000 series printers, select the **3M Changeable UV** setting or the **HP Durable Gloss UV** or **HP Colorfast Vinyl** setting.
- For the Z series printers, refer to HP's website or printer manuals.

Note: The HP printer settings lay down less ink per pass, which results in better ink absorption and quicker drying times.

Drying Guidelines

Usually, the media can be laminated within 10 minutes after printing. However, especially in high humidity conditions, we recommend waiting 15 to 30 minutes before laminating.

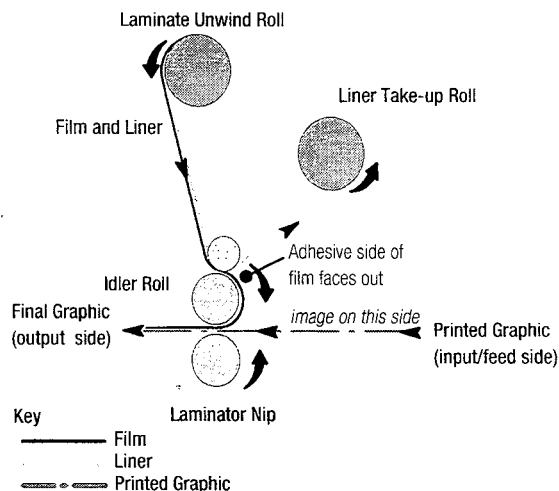
Use care when handling graphics that have not been laminated to avoid scratching and abrasion.

Graphics made with this media and ink combination typically may be wound directly on a take-up roll after printing.

Overlamine

Whether or not you want a warranted graphic, an overlamine is recommended to enhance durability, especially in outdoor applications.

FIGURE 1
Typical Laminator Thread-up



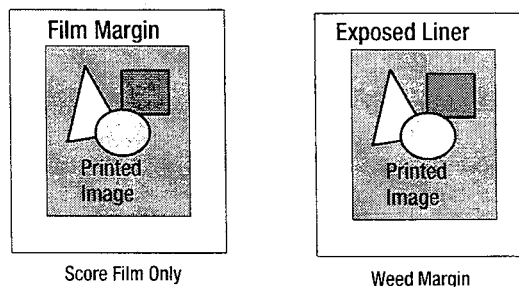
Creating a Laminated Overlap

Creating a laminated overlap helps ensure that the graphic does not peel or lift away from certain banner materials that may be subject to plasticizer migration. This method may also be used for flat, rigid or flexible sign applications.

1. Print the graphic as usual.
2. On all sides of the graphic, score *the film only* to the correct, final graphic dimension *without cutting through the liner*.

Weed away the excess film, leaving the bare liner exposed around the graphic. See FIGURE 2.

FIGURE 2
Trim and Weed Film Margin Only



3. Laminate the graphic as usual (see page 5), making sure that at least one inch of the bare liner is covered by the laminate. See FIGURE 3.